

Date: Friday, 8/31/2007 11:53:30 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 34375		Part Number	: D314095		
Estimate Number	: 11467		Drawing Number	: D3140 REV F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 8/31/2007	S.O. No. : N/A	Drawing Revision	: F		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 9/4/2007		
Previous Run	: 27346		Qty:	6	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	Est. A 02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC Est. rev.C added scuffing NCR 061 EC Est Rev:D As per ECN #829 06-11-20 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		 Comment: Qty.: 0.1549 sf(s)/Unit Total : 0.9293 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 (QQ-A-250/4) .032" thick (M2024T3S.032) 6.40" x 3.81" flat pattern ref.
2.0	SHEAR	 SHEAR
		 Comment: SHEAR Cut as per dwg D3140
3.0	SMALL FAB 1	 SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges
4.0	QC5	 INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/10/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/10/31	3.0	1 part found with a big knock in the side edge of the material.	ROS10/2	Scrap, destroy Qty 1 No replace.	01/10/31	6 01/10/31	ROS10/2	01/10/31

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 34375

Part Number: D314095

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
7.0	PACKAGING 1	PACKAGING RESOURCE #1
8.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D3140	SHEET 1 OF 7
DATE		TITLE	SCALE
06.10.06		DOOR	NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION		
X						D3140-05	DOOR		
	X					D3140-06	DOOR		
		X				D3140-07	DOOR		
			X			D3140-08	DOOR		
				1	X	D3140-09	DOUBLER ASSEMBLY		
					1	D3140-10	DOUBLER ASSEMBLY		
3	3					D3140-57	PAD		
1	1					D3140-59	PAD		
2	2					D3140-61	PAD		
2	2					D3140-63	PAD		
				1	1	D3140-69	PAD		
				1	1	D3140-71	PAD		
				1	1	D3140-73	PAD		
				1	1	D3140-75	PAD		
				1	1	D3140-77	PAD		
				1	1	D3140-79	PAD		
					1	D3140-85	ANGLE	SHOP COPY	
1	1					D3140-87	DOUBLER	RETURN TO	
					1	1	D3140-89	DOUBLER	ENGINEERING
				1		D3140-91	DOUBLER	UNCONTROLLED COPY	
					1	D3140-92	DOUBLER	SUBJECT TO AMENDMENT	
3	3					D3140-95	DOUBLER	WITHOUT NOTICE	
1						D3140-97	DOUBLER	WORK ORDER	
	1					D3140-98	DOUBLER	NO 34375	
				1	1	D3140-99	DOUBLER		
				2	2	D3140-101	DOUBLER		
				1		D3140-103	DOUBLER		
					1	D3140-104	DOUBLER		
				1		D3140-105	DOUBLER		
					1	D3140-106	DOUBLER		
1	1					D3140-241	DOUBLER		
1		1				D3140-301	DOUBLER		
	1		1			D3140-303	DOUBLER		
					5	5	MS20426AD3-4	RIVET	



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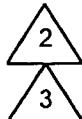
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		D3140	SHEET 2 OF 7
DATE	TITLE		SCALE
06.10.06	DOOR		NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130



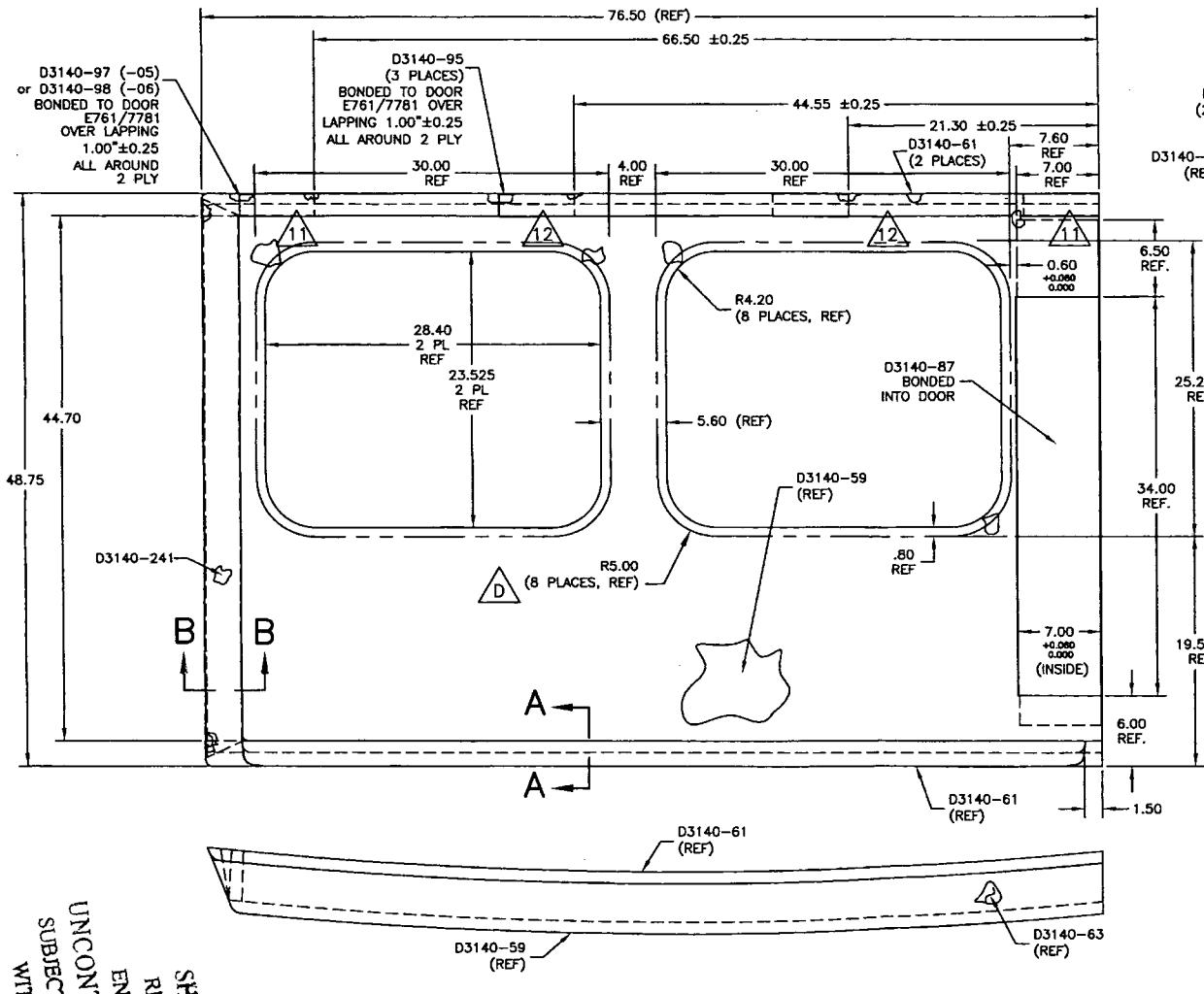
PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETC AND
ALODINE PER DART QSI 005 4.1

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WORK ORDER
NO. 34375



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D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

1 2 3

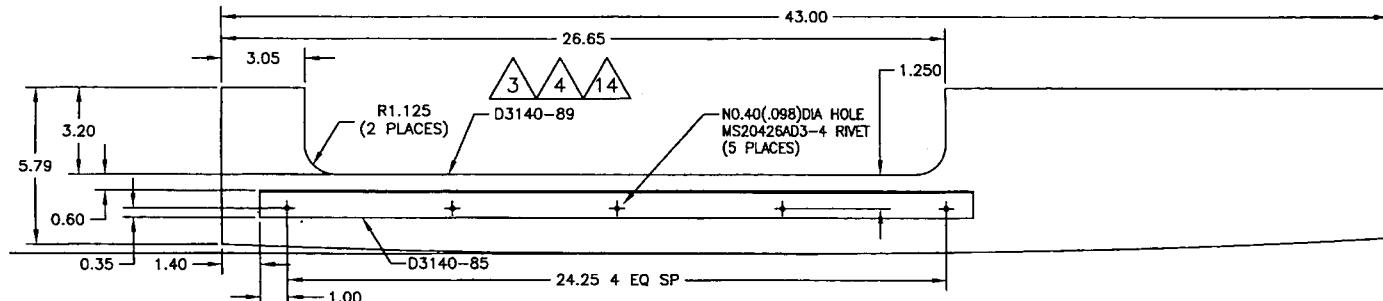
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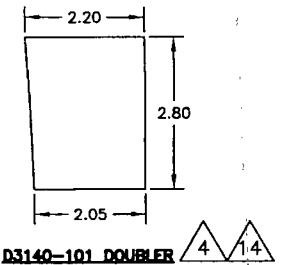
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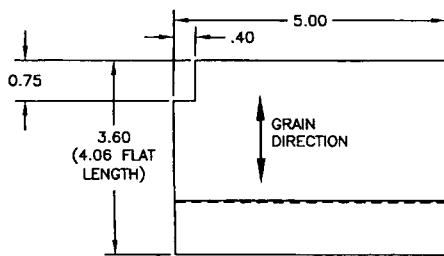
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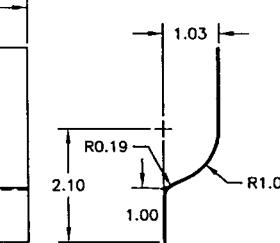
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D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



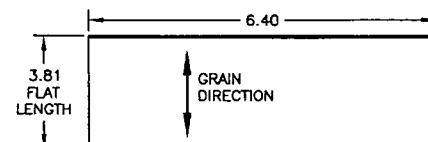
D3140-101 DOUBLER 4 14
 (REPLACES PREMIER P/N B30-23000-101)



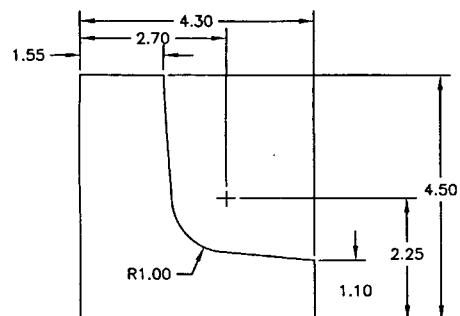
D3140-91F DOUBLER
 (USE TO MAKE D3140-91/-92 DOUBLERS)



D3140-92 DOUBLER 4 14 F
 (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)

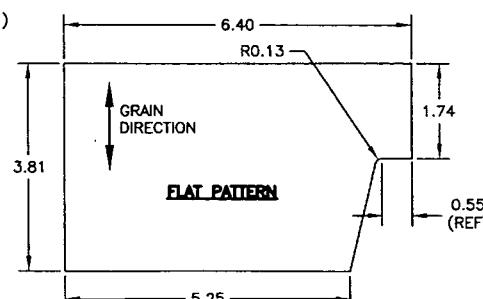


D3140-95 DOUBLER 4 14
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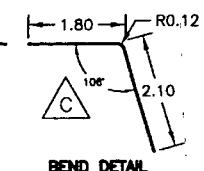


D3140-99 DOUBLER 4 14
 (REPLACES PREMIER P/N B30-23000-99)

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 WORK ORDER 25
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 ENGINEERING
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D3140-97 DOUBLER 4 14
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

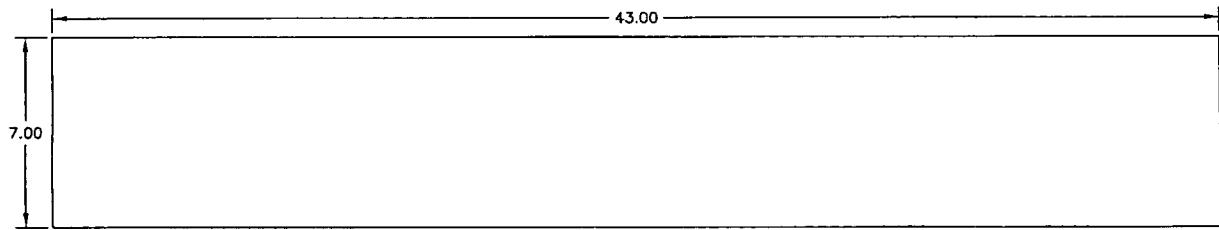


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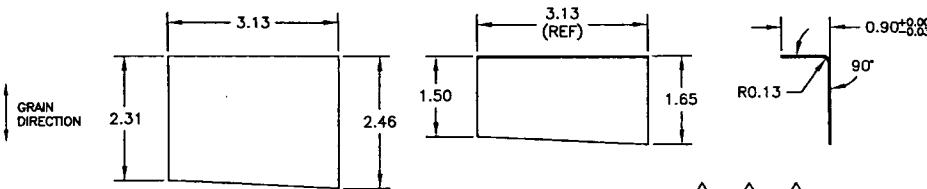
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			NTS



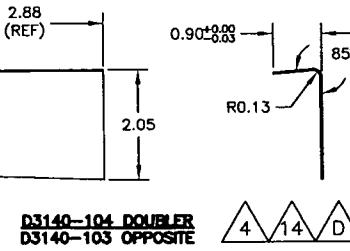
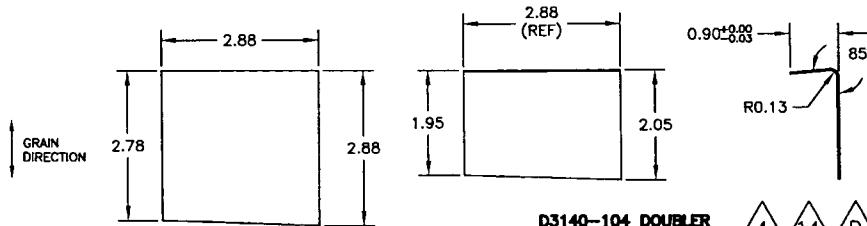
D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106 OPPOSITE

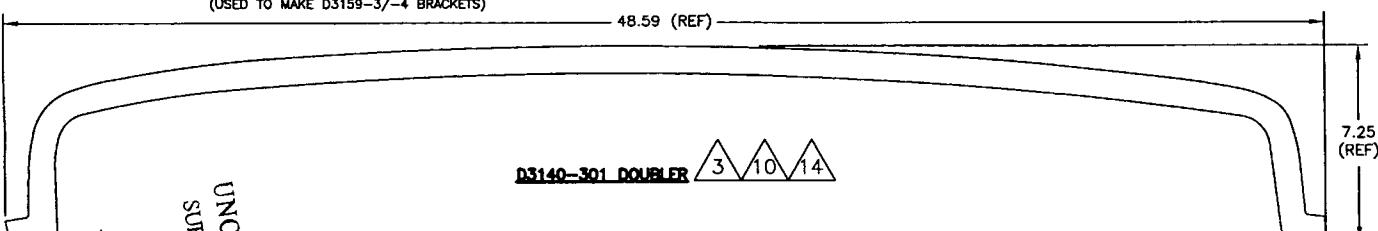
4 14 D



D3140-104 DOUBLER
D3140-103 OPPOSITE

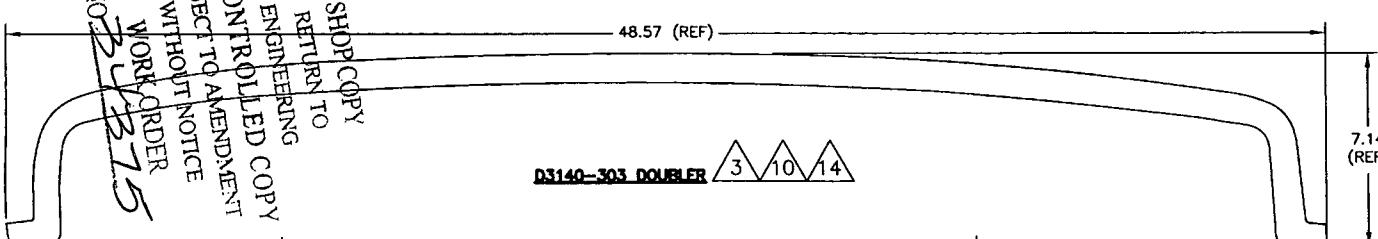
4 14 D F

D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

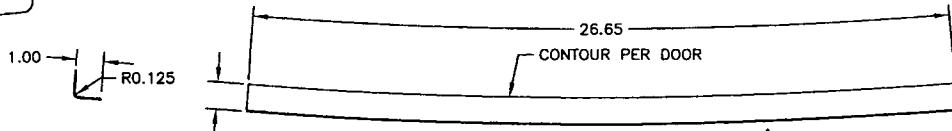


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D3140-301 DOUBLER 3 10 14



D3140-303 DOUBLER 3 10 14

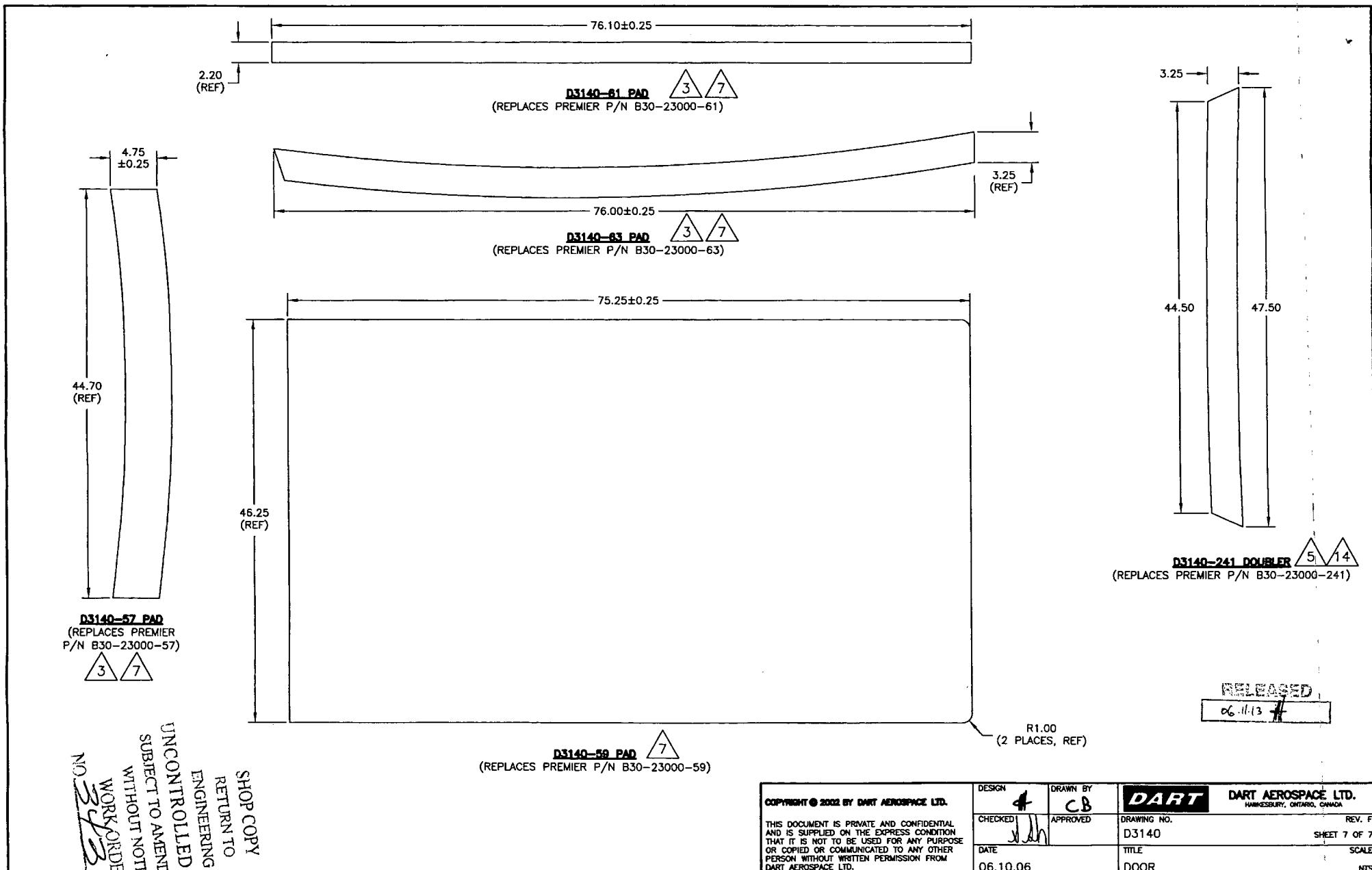


D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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				D3140	SHEET 7 OF 7
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				DOOR	NTS

DART AEROSPACE LTD	Work Order:	34375
Description: Doubler	Part Number:	D 3140-95
Inspection Dwg:	Rev: SHEAR F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>HB</u>	Audited by: <u>EP</u>	Prototype Approval: <u>NA</u>
Date: <u>07-09-02</u>	Date: <u>07/09/04</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	